

Work Order ID 111122

Thursday, January 09, 2014 11:30:44 AM

D3440-13

B 111122

\*111122\*

BFK

Page 1

Item ID: D3440-13

Revision ID:

Item Name: Bracket (Supersedes B67-43001-273)

Start Date: 1/9/2014 Start Qty: 10.00

Required Date: 1/24/2014 Req'd Qty: 10.00

Reference:

D 3440-13

B 111122

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan: MF Date: 14-01-09 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3440	Rev A
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100

\*100\*

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blank: 2.00" x 2.00" x 2.200" long

0.00

0.00

MF 14/01/15

10 0

110

\*110\*

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per Folio FA539 and Dwg D3440Dwg Rev: A Identify as  
D3440-13Folio Rev: A Deburr

0.00

0.00

FB 14/01/20

10 0

120

\*120\*

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

FB 14/01/20

10 0

MISS  
2340-13

Thursday, January 09, 2014 11:30:44 AM

Page 2

10x 14-1-21

DAS  
26  
9-89

MLJ 14-01-21

MLJ 14-01-21

# Picklist Print

Thursday, January 09, 2014 11:30:43 AM

Page 1

Work Order ID: 111122

Parent Item: D3440-13

Start Date: 1/9/2014

Required Date: 1/24/2014

Parent Item Name: Bracket (Supersedes B67-43001-273)

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A05.07.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6B2.000X02.000

Purchased

No

100

f

14.1250

0.1833

2

6061-T6 Bar 2.00 x 2.00

Location

Loc Qty

Loc Code

MAT009

14.125

124443

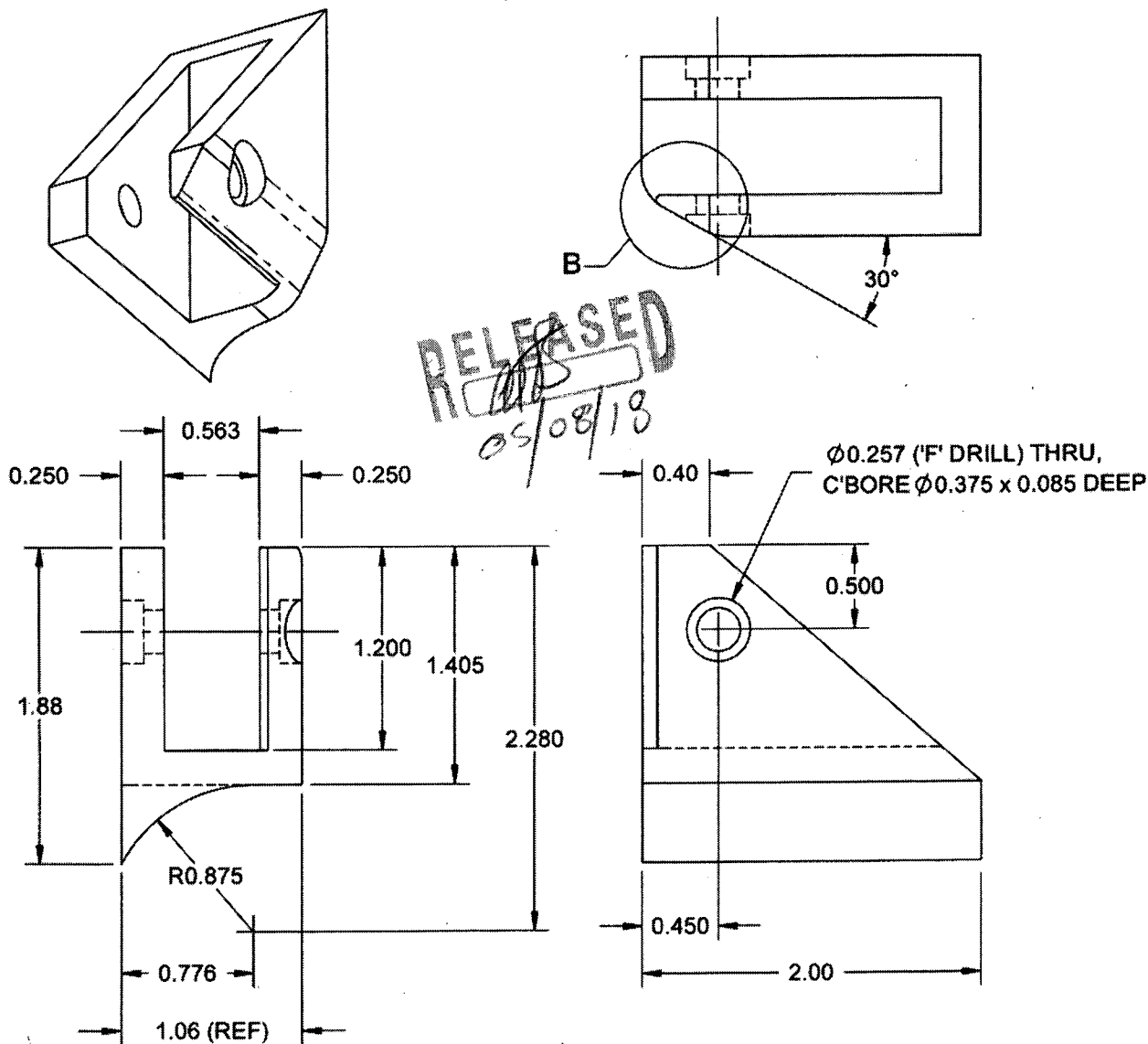
14.125

2.00 *OK* 14/01/15





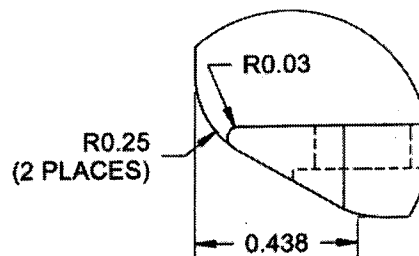
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3440</b>	REV. A SHEET 6 OF 7
DATE <b>05.06.02</b>	TITLE <b>BLADE FOLD KIT PARTS</b>		SCALE 1:1



**D3440-13 BRACKET**  
**SUPERSEDES PREMIER P/N B67-43001-273**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



DETAIL B  
SCALE 2 : 1

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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 11122
<b>Description:</b> Bracket		<b>Part Number:</b> D3440-13
<b>Inspection Dwg:</b> D3440 <b>Rev:</b> A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
30°	+/-0.5°	29.7°	/		A-G	
0.40	+/-0.030	.40	/		FK-04	Vern.
0.500	+/-0.010	.500	/		"	"
0.450	+/-0.010	.451	/		"	"
2.00	+/-0.030	2.00	/		"	"
0.776	+/-0.010	.776	/		"	"
1.06	+/-0.030	1.063	/		"	"
R0.875	+/-0.010	.875	/		R-G	
2.280	+/-0.010	2.280	/		FK-04	Vern.
1.405	+/-0.010	1.403	/		"	"
1.200	+/-0.010	1.200	/		"	"
1.88	+/-0.030	1.884	/		"	"
0.563	+/-0.010	.561	/		"	"
0.250	+/-0.010	.251	/		"	"
0.250	+/-0.010	.251	/		"	"
Ø0.257	+0.006/-0.001	.257	/		"	"
Ø0.375	+0.006/-0.001	.375	/		"	"
0.085	+/-0.010	.085	/		"	"

<b>Measured by:</b> FK	<b>Audited by:</b> DAS 40 9-89	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 14/01/20	<b>Date:</b> 14/01/21	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	

